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(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
5 April 2001 (05.04.2001)

PCT

(10) International Publication Number  
**WO 01/23451 A2**

- (51) International Patent Classification: **C08G 18/00**
- (21) International Application Number: **PCT/NL00/00699**
- (22) International Filing Date:  
29 September 2000 (29.09.2000)
- (25) Filing Language: **English**
- (26) Publication Language: **English**
- (30) Priority Data:  
1013179 30 September 1999 (30.09.1999) **NL**
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- (81) Designated States (*national*): AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
- (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).
- Published:**  
— *Without international search report and to be republished upon receipt of that report.*
- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

(54) Title: PROCESS FOR THE PREPARATION OF A COATING, A COATED SUBSTRATE, AN ADHESIVE, A FILM OR SHEET, FOR THE THUS OBTAINED PRODUCTS AND THE COATING MIXTURE TO BE USED IN THE PROCESS

(57) Abstract: The invention comprises a process for the preparation of a coating, adhesive, film or sheet. In this process a mixture of a polyisocyanate functional, a polyepoxide functional, a polyanhydride functional or a polyketone functional compound or polymer and a compound containing reactive hydrogen, in which the compound containing reactive hydrogen is dispersed in a material which is non-reactive towards the compound containing reactive hydrogen, which mixture is not or low reactive at ambient conditions and high reactive under selected conditions, is applied onto a substrate at ambient temperature, followed by reacting the above compounds at elevated temperatures. At ambient temperature said compound containing reactive hydrogen is a solid material, a powder, a granule, a flake or grind or a mixture thereof which is preferably ground. The invention comprises further the coating mixtures to be used in the process and the coatings, coated substrates, adhesives, films, sheets, impregnated substrates, synthetic leathers, inmould coatings, coated leathers, coated polyvinylchlorides, coated non-wovens, coated coagulated polyurethane substrates, breathable coated substrates, obtained by applying the process.

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Process for the preparation of a coating, a coated substrate, an adhesive, a film or sheet, for the thus obtained products and the coating mixture to be used in the process.

The present invention relates to a process to prepare a coating, adhesive, film or sheet, of the thus obtained products and to the coating mixture to be used in the process.

5           Several methods have been developed for high solids or solvent free application in the polyurethane industry to prepare coatings or films.

10           One approach is the reaction of a polyisocyanate or of a isocyanate functional polyurethane prepolymer with a polyol at 160-180°C. In this way flexible coatings can be prepared with a medium strength. A disadvantage of this method is that the potlife of the mixture is limited to about 3 hours.

15           Further, while a reaction within 2 to 3 min is required, there is only a partial reaction within that time and a post reaction takes place between the unreacted components during storage at ambient temperature. As a consequence the coatings are sometimes tacky immediately after the curing and for example a coated piece of textile cannot be rolled up.

20           A second approach is the reaction between a blocked polyisocyanate and a polyamine or polyol. Especially with polyamines strong films can be obtained. When the blocking agent is a ketoxime, such as butanone oxime, it will evaporate during the reaction, but usually some of the butanone oxime will stay in the film. The result is that, also after application, there may be toxic vapours and the coating smells. Other types of blocking agents, such as dimethylpyrazole and triazole types, malonic esters or acetoacetates, and  $\epsilon$ -caprolactams need a long de-  
30           blocking time and they will partially stay in the coating as not-polymerized molecules. Also in these cases the coatings smell.

A further possibility is the combination of a polyisocyanate and a polyamine from which the amine functions are deactivated by the reaction with a maleic ester under formation of an aspartate. In spite of the deactivation of the amine functions the combination with a polyisocyanate will have a too limited potlife.

An alternative method is the use of internally blocked polyisocyanates which act as crosslinkers mainly in powder coatings. In this method an incorporated uretdion acts as internal blocking agent. At prolonged heating the uretdion unblocks under formation of two isocyanate functions, which further react with a material containing reactive hydrogen. The curing time at 180°C is at least 15 min, which is an unacceptable long time for our applications.

All these systems have some negative aspects such as a too short potlife, a too long reaction time and the evaporation of toxic vapours. We have overcome the described problems and have now developed a new process to prepare a coating, adhesive, film or sheet by a heat curable system.

#### Description of the invention

According to the present invention there is provided a process for the preparation of a coating, adhesive, film or sheet, characterized in that a mixture of a polyisocyanate functional, a polyepoxide functional, a polyanhydride functional or a polyketone functional compound or polymer and a compound containing reactive hydrogen, in which the compound containing reactive hydrogen is dispersed in a material which is non-reactive towards the compound containing reactive hydrogen, which mixture is not or low reactive at ambient conditions and high reactive under selected conditions, is applied onto a substrate at ambient temperature, followed by reacting the above compounds at elevated temperatures.

Surprisingly, the technical problems known in the art are solved and coatings, adhesives, films or sheet are obtained in an easy way by the process of the invention. Surprisingly, it further appeared that the potlife of the coating mixtures of the invention is relatively long, the reaction is relatively fast and no toxic vapours are evaporated from the obtained products.

Since the material containing reactive hydrogen is not or low reactive at ambient temperature towards a polyisocyanate functional, a polyepoxide functional, a polyanhydride functional, or a poly ketone functional compound or polymer such mixtures will have a long pot-life, which is a great advantage in the process. This means, at ambient temperature, such a mixture will be stable for at least 1 day. Several of the compounds containing reactive hydrogen are that inert in a polyketone, polyepoxide or polyanhydride functional compound or polymer that the mixtures are stable as a one pot system.

The material containing reactive hydrogen, is not or low-reactive at ambient temperature because under these conditions the mixture of the isocyanate functional material and the material containing reactive hydrogen form a two phase system, which means it is a heterogeneous system. In the two phase system the compound containing reactive hydrogen is present in the mixture as a solid, a powder, a granule, a flake or a grind or a mixture thereof. The material is preferably ground to obtain a greater reactive area.

The compound containing reactive hydrogen is preferably dispersed in a second material, which material is non-reactive towards said compound containing reactive hydrogen, and not or low reactive towards the isocyanate functional-, the epoxide functional-, the anhydride functional- or the ketone functional compound or polymer at ambient temperature before the desired reaction is effected.

Such a dispersion is obtained by dispersing the material containing reactive hydrogen, in the second mate-

rial by conventional methods which may be by a for example  
a disperser or a pearl mill. By dispersing the compound  
containing reactive hydrogen in an inert material a smaller  
particle size and a greater area can be obtained than  
5 when the pure solid is ground.

The compound containing reactive hydrogen reacts  
fast with a polyisocyanate functional, a polyepoxide functional,  
a polyanhydride, or a polyketone functional compound or polymer  
under selected conditions. Such a condition may be a sudden  
10 increase of temperature. At that moment the material containing  
reactive hydrogen will melt or dissolve in the system, the  
reactive sites of the molecules can move freely, and while the  
mixture is homogenised by diffusion, the reaction with the  
polyisocyanate functional, the polyepoxide functional, the  
15 polyanhydride functional, or the polyketone functional compound  
or polymer occurs.

The homogenisation at higher temperatures will be  
more efficient and as a result the reaction will be faster  
20 and more complete. Moreover, the performance of the films  
or coatings will be better when the particle size of the  
material containing reactive hydrogen, is small.

An excellent film or coating quality is obtained  
when the particle size is between 0,5 and 200  $\mu\text{m}$ . A more  
25 preferable particle size is between 0,5 and 60  $\mu\text{m}$  and the  
most preferable size is between 0,5 and 15  $\mu\text{m}$ .

To obtain a maximal potlife, the material containing  
reactive hydrogen may not melt or soften in the reaction  
mixture at ambient temperature.

30 Several types of material containing reactive hydrogen  
may be used in the process such as polyhydrazides,  
polysemicarbazides, polysulphonyl hydrazides, carbohydra-  
zide, guanidine or guanidine salts, polyamines or polyamine  
salts.

35 Said polyhydrazide which may be used in the process  
of the invention may be oxalic dihydrazide, malonic  
dihydrazide, succinic dihydrazide, adipic dihydrazide, se-  
bacic dihydrazide, dodecanoic dihydrazide, isophthalic di-

hydrazide, piperazine N,N'-dihydrazide, m-benzene-dihydrazide, p-benzene-dihydrazide.

Preferably adipic dihydrazide and carbodihydrazide are used since they are inert in the reaction mixtures with an epoxide functional-, an anhydride functional- or a ketone functional compound or polymer at ambient temperature for at least one year. They further reacts instantaneously with a polyisocyanate, a polyepoxide, a polyanhydride or a polyketone functional compound or polymer at temperatures of 80-180°C or higher.

A polysemicarbazide which may be used in the process of the invention is selected from ethane-disemicarbazide, butane-disemicarbazide, propane-disemicarbazide, hexane-disemicarbazide, para-benzene-disemicarbazide, toluene-2,4-disemicarbazide, toluene-2,4-disemicarbazide, bis (4-semicarbazido-phenyl)ether, bis (4,4'-hydrazido)-3,3'-dimethoxy biphenyl, di-N,N'-methylamino urea, 4,4'-methylene-bis(cyclohexene semicarbazide), 3-semicarbazido-methyl-3,5,5-trimethylcyclohexyl-semicarbazide or mixtures thereof.

A polysulphonylhydrazide which may be used in the process of the invention is selected from p,p'-oxybis benzene sulphonyl hydrazide; bis(methylhydrazido)sulphate, bis (methylhydrazidosulphonyl)piperazine, or bis p-(hydrazidosulphonylamino)benzene.

Usually, guanidine hydrochloride, guanidine acetate, guanidine carbonate and guanidine nitrate are suitable a guanidine salts.

A suitable polyamine or polyamine salt may be piperazine, piperazine diacetate, piperazine dihydrochloride, lysine, lysine hydrate, diaminoisophorone diacetate, diaminoisophorone dihydrochloride.

As mentioned before it is preferable when the compound containing reactive hydrogen is used as a dispersion in a material which is inert to both the reactive hydrogen compound and the second reagent of the reaction. This material is preferably a polyether, a polyester, a polycarbonate, a polyacrylate, a polyvinylalkylether, a

polyurethane, optionally substituted by substituents which are non reactive towards the material containing reactive hydrogen, and non- or low reactive towards the isocyanate functional material or is a plasticizer of the group of phthalic alkylesters, adipic alkyl esters, sebacic alkyl esters, dodecanoic alkyl esters, polyesters, phosphate esters, fatty esters, straight and modified natural or mineral oils, sulphonated oils, ethoxylated oils, epoxidised oils, fatty acids, sulphon amides, fat liquors, lecithine or a mixture thereof, optionally mixed with water.

An important aspect of the invention is that a low solvent level can be used during the process, and most preferably the process is solvent free.

In the process of the invention a polyisocyanate functional compound or polymer, a polyketone functional compound or polymer, a polyepoxide functional compound or polymer, or a polyanhydride functional compound or polymer and the material containing reactive hydrogen are mixed together in an stoichiometric ratio of 0.5 to 1.5, and preferably in a ratio of 0.9 to 1.2, whereafter the obtained mixture is applied onto a substrate and the covered or impregnated substrate is heated to a temperature of 50 to 300°C for 1-20 min and preferably to 80 to 200°C for 1 to 10 min.

Surprisingly it appeared that the reaction takes place as well when the polyisocyanate functional compound or polymer and the material containing reactive hydrogen are mixed together in a stoichiometric ratio of 0.5-1.5 and preferably in a ratio of 0.9 -1.1 whereafter the obtained mixture is applied onto a substrate and the covered or impregnated substrate is immersed into water of 20 to 100°C for 0.5 to 10 min.

The isocyanate functional compound or polymer which is used in the process of the invention is usually a polyisocyanate or a isocyanate functional polyurethane prepolymer.



Urea functions are formed by the reaction of the isocyanate functions and the  $\text{NH}_2$ -functions of the material containing reactive hydrogen.

5 The ketone functional compound or polymer of the invention is preferably a ketone functional polymer polyurethane with in-chain, pendant and/or terminal ketone functions. Ketimine functions are formed by the reaction of the ketone and the  $\text{NH}_2$ -functions of the material containing reactive hydrogen.

10 The anhydride functional compound of the invention is usually a polyanhydride or a copolymer containing anhydride functions. Amide functions are formed by the reaction of the anhydride function and the  $\text{NH}_2$ -functions of the the material containing reactive hydrogen.

15 The epoxide functional compound of the invention is usually a polyepoxide or a epoxy functional polymer. The epoxide rings are opened during the reaction with the  $\text{NH}_2$ -functions of the material containing reactive hydrogen and secondary or tertiary amines are formed.

20 A further part of the invention are the coatings, coated substrates, adhesives, films, sheets, impregnated substrates, synthetic leathers, inmould coatings, coated leathers, coated polyvinylchlorides, coated non-wovens, coated coagulated polyurethane substrates, breathable coated substrates which are obtained by the process of the  
25 invention.

The thus obtained films or coatings are strong, dry, flexible and UV-resistant.

30 The process and application results of the present invention are profitable regarding to conventional heat curable systems which are low-solvent or solvent-free. Regarding to the system in which a polyisocyanate functional compound or polymer reacts with a polyol the mixture of the present invention has a longer pot life,  
35 while the reaction is faster, almost instanteneous, and more complete at elevated temperatures. The obtained films or coatings are stronger because in the process of the invention urea functions are formed by the reaction of the

isocyanate function and the amine or hydrazide, while in the reaction of a isocyanate and a OH-function a urethane function is formed. It is wellknown that an urea function gives additional strength because of the presence of hydrogen at the N of the urea function which makes it possible to form hydrogen bridges.

Regarding to the systems in which blocked isocyanates are used in combination with polyamines films or coatings of comparable strength are formed by the process of the invention, but the elongation and the tension at break is larger. The potlife of the mixture of the present invention is longer, there are no evaporating toxic reactants such as butanone oxime, or remaining low molecular material such as dimethylpyrazole and triazole types, malonic esters or acetoacetates and the resulting films or coatings do not smell. As a consequence the process of the invention will not have any damaging effect on the environment.

Regarding to the systems in which a polyisocyanate is reacted with a polyamine from which the amine functions are deactivated by the reaction with a maleic ester under formation of a aspartate, the mixtures of the process of the invention have a much longer potlife.

Regarding to the system in which an incorporated uretdion acts as internal blocking agent the reaction time is much shorter at elevated temperatures.

Finally the invention provides a coating mixture comprising on the one side a isocyanatefunctional compound, a polyepoxide functional compound, a polyanhydride functional compound, or a polyketone functional compound and on the other side a compound containing a reactive hydrogen which is not or low reactive at ambient temperature and highly reactive under selected conditions, which coating mixture is applied in the process of the present invention.

The coating mixture of the invention is stable at ambient temperature for at least one day and preferably the coating mixture of the epoxide functional-, the anhy-

dride functional- or the ketone functional compound or polymer and the compound containing reactive hydrogen is stable at ambient temperature as a one pot system.

The compound containing reactive hydrogen is present in the mixture as a solid, a powder, a granule, a flake or a grind or a mixture thereof and is preferably ground.

As mentioned before it is preferable when the compound containing reactive hydrogen is used as a dispersion in a material which is inert to both the reactive hydrogen compound and the second reagent of the reaction.

The particle size of the ground or of the dispersion of the compound containing reactive hydrogen is from 0,5 to 200  $\mu\text{m}$ , preferably from 0.5 to 60  $\mu\text{m}$  and most preferably from 0.5 to 15  $\mu\text{m}$ .

The mixtures of the isocyanate functional material and the material containing reactive hydrogen, may be applied onto a substrate. They may be used as films, sheets, in adhesives, sealants, printing ink and in coatings. They may be applied on any substrates, including leather or artificial leather, metals, wood, glass, plastics, paper, paper board, textile, non-woven, cloth, foam and the like by conventional methods, including spraying, flow-coating, reverse-coating, brushing, dipping, spreading and the like. The cured material may be further treated with coatings, such as a top-coat, or adhered to any substrate by direct or transfer coating technics.

Many additives may be present for application reasons, for example fillers, colorants, pigments, silicones, fire retardants, matting agents, flow agents, foaming agents and the like.

Some applications where the process of the invention is used are of special interest.

For example, the process may be used for the preparation of a coated textile to be used as a synthetic leather. Such a process may comprise the preparation of an adhesion coat onto textile, followed by applying a mixture of a polyurethane prepolymer and a hydrazide-, semicarba-

zide-, amine or amine salt- dispersion of the invention onto the adhesion coat and curing of this mixture at an elevated temperature, which may be between 80 and 250°C. The coating may further be embossed at 80 to 250°C.

5 By repeating of the process described above on the backside of the textile a double sided coated textile may be obtained.

Alternatively the process may be used for the preparation of a coated substrate to be used as synthetic  
10 leather by transfer coating, which may comprise the preparation of a skincoat onto release paper, followed by the preparation of an intermediate coat by applying a mixture of a polyurethane prepolymer and a hydrazide-, semicarbazide-, amine or amine salt- dispersion of the invention  
15 onto the skincoat and curing of this mixture at an elevated temperature, which may be between 80 and 250°C, whereafter an adhesive coat is applied onto the intermediate coat in which a piece of textile is laminated and the thus obtained material is dried, whereafter the release paper  
20 is removed.

The process described above may also be used for the preparation of for example coated leather, coated polyvinyl chloride, coated non-woven, coated coagulated polyurethane substrates.

25 Alternatively the process may be used for the preparation of a coated polyvinyl chloride to be used as synthetic leather by transfer coating, which may comprise the preparation of a skincoat onto release paper, followed by the preparation of an intermediate coat by applying a  
30 mixture of a polyurethane prepolymer and a hydrazide-, semicarbazide-, amine or amine salt- dispersion of the invention onto the skincoat and curing of this mixture at an elevated temperature, which may be between 80 and 250°C, whereafter a compact polyvinylchloride substrate onto the  
35 high solids coat is prepared by applying a polyvinylchloride paste onto the high-solids coat, optionally followed by laminating of a piece of textile into the polyvinyl-

chloride paste, and curing of the polyvinyl chloride paste.

The process may further be used in the preparation of a moulded material by inmould coating which comprises spraying of a mixture of a polyurethane prepolymer and a hydrazide-, semicarbazide-, amine or amine salt-dispersion of the invention, and optionally a non-reactive solvent into a matrix until a desired coating thickness is obtained. The matrix may be heated during the spray process, or after the spraying process. After the curing the moulded material may be removed.

Various aspects of the present invention are illustrated by the following examples. These examples are only illustrative of the invention and are not limiting the invention as claimed hereafter.

### Examples

#### Example 1

Preparation of an aliphatic polyether based isocyanate functional polyurethane prepolymer.

Under a nitrogen atmosphere 112.78 g (507.56 mmole) of 3-isocyanatomethyl-3,5,5-trimethylcyclohexylisocyanate (hereafter referred to as IPDI) was added to a mixture of 139.21 g (138.24 mmole) of a polypropylene glycol with a molecular weight of 1007, 163.77 g (81.89 mmole) of a propylene glycol with a molecular weight of 2000 and 4.2 g (31.34 mmole) of trimethylol propane at 60-70°C while stirring. The mixture was heated to 100°C and reacted at this temperature for 2 hrs to form a polyurethane prepolymer. After 1 hr of reaction time 0.1 g of tinocatoate was added as a catalyst. The reaction mixture was cooled down. The amount of remaining NCO was measured and appeared to be 4.43%.

#### Example 2

Preparation of an aliphatic polyester based isocyanate functional polyurethane prepolymer.

Under a nitrogen atmosphere a 107.12 g (482 mmole) of IPDI was added to a mixture of 141.81 g (151.67 mmole) of a polyester diol with a molecular weight of 935 available from Occidental as Ruco S 1015-120, 166.83 g (55.61 mmole) of a polyesterdiol with a molecular weight of 3000 available from Occidental as Ruco S 1015-35 and 4.2 g (31.34 mmole) of trimethylol propane at 60-70°C while stirring. The mixture was heated to 100°C and reacted at this temperature for 2 hrs to form a polyurethane prepolymer. After 1 hr of reaction time 0.1 g of tin octoate was added as a catalyst. The reaction mixture was cooled down. The amount of remaining NCO was measured and appeared to be 3.99%.

#### Example 3

Preparation of an aromatic polyether based isocyanate functional polyurethane prepolymer.

The procedure of example 1 was repeated with the exception that the IPDI was replaced by 88.31 g (507.56 mmole) of toluene diisocyanate (hereafter referred to as TDI) and the reaction was executed at 90-95°C. The NCO amount appeared to be 4.60%.

#### Example 4

Preparation of an aromatic polyester based isocyanate functional polyurethane prepolymer.

The procedure of example 2 was repeated with the exception that the IPDI was replaced by 85.61 g (492 mmole) of TDI and the reaction was executed at 90-95°C. The NCO amount appeared to be 4.23%.

#### Example 5

Preparation of a ketone functional polyurethane polymer from a isocyanate functional polyurethane prepolymer and hydroxyacetone

Under a nitrogen atmosphere a mixture of 100 g of the polyurethane prepolymer from example 1 and 7.81 g (105.48 mmole) of hydroxyacetone were heated to 100°C. The

mixture was stirred for 2 hrs at 100°C. After 1 hr of reaction time 0.1 g of tinocatoate was added as a catalyst. The disappearance of NCO was checked by IR-spectroscopy by following the NCO signal at 2269 cm<sup>-1</sup>.

5

#### Example 6

Preparation of a ketone functional polyurethane polymer.

Under a nitrogen atmosphere 68.42 g (308 mmole) of IPDI was added to 251 g (171 mmole) of a ketone functional polyester diol obtainable from NeoResins as PEC 205 in 80 g of dipropylene glycole dimethyl ether at 60°C while stirring. The mixture was heated to 100°C and reacted at this temperature for 2 hrs to form a polyurethane prepolymer. After 1 hr of reaction time 0.1 g of tinocatoate was added as a catalyst. The reaction mixture was cooled down. The amount of remaining NCO was measured using a sample of 10 g, and appeared to be 2.71.

18.65 g (252 mmole) of methoxyethylamine was added to the obtained polyurethane prepolymer and the mixture was stirred for 15 min at 20°C. The disappearance of NCO was checked by IR-spectroscopy by following the NCO signal at 2269 cm<sup>-1</sup>.

25

#### Example 7

Preparation of a ketone functional polyurethane polymer from a isocyanate functional isocyanurate and hydroxyacetone

Under a nitrogen atmosphere a mixture of 151 g (259 mmole) N,N',N''-triisocyanatohexylisocyanurate and 57.50 g (777 mmole) of hydroxyacetone in 52.13 g of dipropylene glycol dimethyl ether were heated to 90°C. The mixture was stirred for 2 hrs at 90°C. After 1 hr of reaction time 0.1 g of tinocatoate was added as a catalyst. The disappearance of NCO was checked by IR-spectroscopy by following the NCO signal at 2269 cm<sup>-1</sup>.

## Example 8

Comparative example: preparation of a film from a MEK-oxime blocked polyurethane polymer and a amine functional crosslinker.

5           9.39 g (105.48 mmole) of mekoxime was added to 100 g of the prepolymer of example 1 at 60-65°C. The mixture was stirred for 2 hrs at 70°C. The disappearance of the NCO was checked by the absence of the NCO-signal in the Infrared spectrum at  $2270\text{ cm}^{-1}$ . The product was cooled  
10 down and mixed with 12.47 g (52.4 mmole) of 3,3'-dimethyl-4,4'-diamino-dicyclohexyl-methan and 0.1 g of a 10 % solution of dibutyltinlaureate in dipropylene glycol dimethyl ether as catalyst.

200  $\mu\text{m}$  films were prepared and cured at 180°C for  
15 5 min.

## Example 9

Comparative example: preparation of a film from a OH-functional polyurethane polymer and a NCO-crosslinker

20           A: preparation of the OH-functional polyurethane polymer:

Under a nitrogen atmosphere 264 g (132 mmole) of a polypropyleneglycol with a molecular weight of 2000 and 7.92 (88 mmole) of 1,3-butanediol were heated to 80°C.  
25 97.68 (440 mmole) of IPDI was added and the mixture was stirred for 2 hrs at 100°C. After 1 hr of reaction time 0.1 g of tinocatoate was added as a catalyst. The reaction mixture was cooled down and the amount of remaining NCO in the resulting prepolymer was determined by titration and  
30 appeared to be 4.6%. 36.21 g (402 mmole) of 1,3- butanediol and 0.1 g of dibutyl tinlaureate were added and the mixture was heated to 100° for two hrs. The disappearance of the NCO was checked by the absence of the NCO-signal in the Infrared spectrum at  $2270\text{ cm}^{-1}$ . The product was cooled  
35 down and had an OH-amount of 2.13 meq/g

B: preparation of an NCO-crosslinker: 14.4 g (240 mmole) of n-propanol was added within 30 min to 102.2 gr (containing 600 mmole of NCO) of N,N',N''-triisocyanato-



hexylisocyanurate, whereafter the mixture was stirred and heated at 80° for 2 hrs . After 1 hr of reaction time 0.1 g of tinocatoate was added as a catalyst. The reaction mixture was cooled down and the amount of remaining NCO in the resulting polymer was determined by titration and appeared to be 12.0

A 200  $\mu$ m film was prepared from a mixture of 13 gr of the product of A and 9.2 g of the product of B with 0.05 g of a 10 % solution of dibutyltinlaureate in dipropylene glycol dimethyl ether as catalyst. The film was cured for 5 min at 160°C.

#### Example 10

Preparation of a semicarbazide from 4,4'-methylene-bis(cyclohexylisocyanate) and hydrazine.

26.2 g (100 mmole) of 4,4'-ethylenebis(cyclohexylisocyanate) in 26.2 g of dipropylene glycol dimethyl ether was added to 12 g (240 mmole) of hydrazine hydrate in 18 g of isopropanol and 12 g of of dipropylene glycol dimethyl ether while keeping the temperature below 25°C by cooling with ice. A white precipitate appeared. After stirring for 30 min the precipitate was filtered of and rinsed with dipropylene glycol dimethyl ether. The product was dried at 80°C. The yield was 44.42 g = 88.9 % from the theoretical amount.

#### Example 11

Preparation of a semicarbazide from hexamethylene diisocyanate and hydrazine.

33.6 g (200 mmole) of hexamethylenediisocyanate in 33.6 g of dipropylene glycol dimethyl ether was added to 24 g (480 mmole) of hydrazinehydrate in 27 g of isopropanol and 24 g of of dipropylene glycol dimethyl ether while keeping the temperature below 25°C by cooling with ice. A white precipitate appeared. After stirring for 30 min the precipitate was filtered of and rinsed with dipropylene glycol dimethyl ether. The product was dried at

80°C. The yield was 41.95 g = 84.9 % from the theoretical amount.

#### Example 12

5 Preparation of a semicarbazide from a commercial mixture of toluene diisocyanate and hydrazine.

34.8 g (200 mmole) of a commercial mixture of toluene diisocyanate in 33.6 g of dipropylene glycol dimethyl ether was added to 24 g (480 mmole) of hydrazine hydrate  
10 in 24 g of isopropanol and 24 g of water while keeping the temperature below 25°C by cooling with ice. A white precipitate appeared. After stirring for 30 min the precipitate was filtered off and rinsed with dipropylene glycol dimethyl ether. The product was dried at 80°C.

15 The yield was 34.78 g = 69.3 % from the theoretical amount.

#### Example 13

20 Preparation of a semicarbazide from 3-isocyanatomethyl-3,5,5-trimethylcyclohexylisocyanate and hydrazine.

44.4 g (200 mmole) of IPDI in 33.6 g of dipropylene glycol dimethyl ether was added to 24 g (480 mmole) of hydrazine hydrate in 24 g of isopropanol and 24 g of water while keeping the temperature below 25°C by cooling  
25 with ice. The mixture was stirred for 1 hr and the solvents were evaporated. The mixture was crystallized from isopropanol.

#### Example 14

30 Preparation of a grind and of a dispersion of adipic dihydrazide.

Adipic dihydrazide was ground as a pure powder or it was ground in a 1:1 weight ratio in di(ethylhexyl) adipate in the presence of 0.5 % of Triton X-100. By increasing the dispersion time and the speed of the stirring  
35 blade smaller particle sizes could be obtained. The grinds and dispersions which were obtained are presented in

Table I. The range of the particle size in the dispersions were measured by microscopy

5 Table 1 Particle sizes of adipic dihydrazide in a pure grind or as a dispersion in di(ethylhexyl) adipate

Example	medium	particle size of adipic dihydrazide in the medium ( $\mu\text{m}$ )
		Range
14 A	Pure	30-300
14 B	pure, ground	30-250
14 C	di(ethylhexyl)adipate	40-150
14 D	di(ethylhexyl)adipate	30- 60
14 E	di(ethylhexyl)adipate	5- 40
14 F	di(ethylhexyl)adipate	0.5-13

#### Example 15

10 Preparation of a dispersion of adipic hydrazide in different liquid materials which are none non-reactive towards the adipic dihydrazide.

Adipic hydrazide was dispersed in a 1:1 weight ratio in liquid materials which were non-reactive towards the adipic dihydrazide in the presence of 0.5 % of Triton X-100 by a Dispermat pearl mill configuration for 1.5 hrs at 5000 rpm. The range of the particle size in the dispersions depending on the medium were measured by microscopy. The results are presented in Table 2. The results show that the values for the particle size in a more polar medium are slightly less than in an apolar medium.

25 Table 2 Particle size of adipic dihydrazide as dispersion in several media

Example	medium	particle size of adipic dihydrazide in the medium ( $\mu\text{m}$ )
		range
15A	di(ethylhexyl)adipate	30 - 60
15B	dibutyl phthalate	30 - 60
15C	dioctyl phthalate	30 - 60
15D	dibutyl sebacate	30 - 60
15E	polyethylene glycol	10 - 30
15F	tributoxyethylphosphate	10 - 30
15G	soybean lecithin	10 - 30
15H	castor oil	10 - 30
15I	N-methyl pyrrolidone	10 - 30
15J	dipropylene glycol	10 - 30
	dimethylether	

## Example 16

Preparation of a dispersion of several dihydrazides, disemicarbazides, a di(sulphonylhydrazide), amine salts.

Several dihydrazides, disemicarbazides, sulphonyldihydrazides and diamine salts were ground in di(ethylhexyl) adipate or in tributoxyethyl phosphate or in N-methylpyrrolidone by a Dispermat pearl mill configuration for 1.5 hrs at 5000 rpm. The products which were ground were: carbodihydrazide, oxalic dihydrazide, succinic dihydrazide, adipic dihydrazide, sebacic dihydrazide, dodecanoic dihydrazide, isophthalic dihydrazide, the products of example 10, 11, 12 and 13, 4,4'-oxybis(benzenesulphonylhydrazide), guanidine hydrochloride, lysine.

In all cases the particle sizes of the hydrogen reactive materials in the dispersions were measured by microscopy. The ranges in di(ethylhexyl) adipate were comparable and were between 30 and 60  $\mu\text{m}$ . The values in tributoxyethyl phosphate or in N-methylpyrrolidone were slightly less and were 10-30  $\mu\text{m}$ .

## Example 17

Kinetics of the curing of the prepolymers of example 1, 2, 3 and 4 with adipic dihydrazide at several temperatures and times, measured by infrared spectroscopy.

The reaction of the prepolymers of example 1, 2, 3 and 4 with the adipic hydrazide dispersion of example 15 A (containing 5.716 meq of hydrazide/g) was followed at several temperatures by infrared spectroscopy. Further the potlife of the mixtures at 50°C were controlled.

50 gr of a polyurethane prepolymer of example 1, 2, 3, or 4 was mixed with a stoichiometric amount of the adipic dihydrazide dispersion and a film was prepared onto a sodium chloride cell. An Infrared spectrum was prepared which showed a large NCO signal at 2260  $\text{cm}^{-1}$ . The cell was heated at 140, 160 or at 180°C for several minutes and the

decrease of the NCO-signal was measured by IR-spectroscopy. The results are presented in Table 3.

The results show that the IPDI-based prepolymers from example 1 and 2 are more reactive than the TDI-based prepolymers from example 3 and 4, which is indicated by a faster disappearance of the NCO-signal. There is not a significant difference in reactivity between the polyether and the polyester prepolymers.

Further the mixtures were stable for at least 6 weeks at 50°C and at that moment the intensity of the signals of the NCO in the IR-spectrum were comparable with that of the freshly prepared mixtures.

Table 3 decrease of the NCO signal in the infrared spectrum during the curing reaction of isocyanate functional prepolymers of example 1, 2, 3 and 4 with an adipic acid dispersion in di(ethylhexyl) adipate

Product of Example	Curing Temperature (°C)	amount of remaining NCO (%) after <sup>a</sup>			
		4 min	6 min	9 min	15 min
1	140	19.0	5.7	2.5	1.2
	160	1.5	0,3	0	0.3
2	140	26.5	5.9	2.2	1.2
	160	1.2	0.1	0	0
3	140	na	78.9	55.9	49.6
	160	na	25.2	10.3	8.2
	180	17.4	9	5.5	2.2
	200	3.2	1.5	1.0	0.7
4	140	na	89.0	58.8	51.1
	160	na	49.7	11.5	8.5
	180	19.4	9.8	5.6	2.4
	200	5.4	2.7	1.5	1.2

Notes to table 3:

a) determined by measuring the area of the signal at 2260-70 cm<sup>-1</sup> from the NCO-signal regarding to the carbonyl signal at 1740 cm<sup>-1</sup>.

b) na = not available

## Example 18

Kinetics of the film formation by curing of the polyurethane prepolymer of example 2 and 4 with adipic dihydrazide or carbodihydrazide at several temperatures and times.

50 gr of polyurethane prepolymer of example 2 (based on IPDI, which is an alifatic diisocyanate) or 4 (based on TDI, which is an aromatic diisocyanate) were mixed with an stoichiometric amount of the adipic dihydrazide dispersion of example 15 A or of the carbodihydrazide dispersion of example 16 and the mixtures were applied on-to release paper. The curing of the films was checked at 120, 140 and at 160°C at 1, 2, 3, 6 and 12 min. The results are presented in tabel 4. Both, aromatic and aliphatic prepolymers are completely reacted with the carbodihydrazide or with the adipic dihydrazide after 3 min. at 160°C. Regarding to example 17 the reaction is faster because the sodium chloride cell needs more time for warming up than release paper. When the film formation was complete flexible films were obtained.

Table 4: Film formation by curing of a polyurethane prepolymer of example 2 and 4 with adipic dihydrazide or carbodihydrazide at several temperatures and times

poly-urethane of example	hydrogen reactive material	curing temp. (°C)	phase of the film <sup>a)</sup> at a curing time of				
			1 min	2 min	3 min	6 min	12 min
2	adipic dihydrazide	120	w	w	w	t	r
		140	t	r-i	r	r	r
		160	r-i	r	r	r	r
2	carbodi-hydrazide	120	w	w	t	t	r
		140	t	t	r-i	r	r
		160	r-i	r	r	r	r
4	adipic dihydrazide	140	w	w	w	w	t
		160	r-i	r	r	r	r
4	carbodi-hydrazide	140	r-i	r	r	r	r
		160	r-i	r	r	r	r

## Notes to Table 4

a) w : the mixture is still wet; no reaction is observed

- t : the mixture is tacky; a partial reaction is effected
- r-i : film formation is effected, but the film is not strong, which means that the reaction is incomplete
- r : complete film formation is effected

### Example 19

Preparation of films by curing a prepolymer of example 2 and adipic dihydrazide powder or dispersion of example 14 and measurement of the homogeneity of the films depending on the particle size of the adipic dihydrazide.

3.48 g (20 mmole) of ground adipic dihydrazide or 7.00 g (20 mmole) of an adipic dihydrazide dispersion in di(ethylhexyl)adipate of example 15 A was stirred into 50 g (containing 40 meq of NCO) of the prepolymer of example 2. Films of 200  $\mu$ m were prepared onto a black coated glossy paper and heated for 3 min at 160°C. The gloss of the films was measured by a reflectometer. Further films of 200  $\mu$  were prepared on transparent polyester sheets and the transparency of the films was determined by measuring the transmission by spectroscopy at 550 nm on a Hitachi model 101 spectrophotometer. The gloss and the transparency of the films is a measure for the homogeneity of the films. The results of the tests are in table 5. It appeared that when the particle size of the adipic dihydrazide was small, the gloss and the transparency of the films were maximal.

Table 5: Homogeneity of cured films depending on the particle size of the adipic dihydrazide

Adipic hydrazide grind originated from example	particle size of the adipic dihydrazide in the grind ( $\mu$ m)	gloss of cured films of 200 $\mu$ m	transmission of cured films of 200 $\mu$ m(%)
	range		
14 A	30 - 300	7.8	52.2
14 B	30 - 250	8.5	64.5
14 C	40 - 150	27	85.0
14 D	30 - 60	46	93.5
14 E	5 - 40	60	94.6
14 F	0.5 - 13	95	97.0

## Example 20

Preparation of a film by curing a polyether polyurethane prepolymer and a adipic dihydrazide dispersion and comparing the film with the film of example 8 and of example 9.

9.28 g (26.5 mmole) of an adipic dihydrazide dispersion of example 15 A was stirred into 50 g (containing 53 meq of NCO) of the prepolymer of example 1. Films of 200  $\mu$ m were prepared and reacted for 3 min at 160°C. The mechanical properties of the films were determined and compared to those of the films of the high solid systems of comparative examples 8 and 9. The results are shown in table 6.

The results show that regarding to the films of example 8 and 9 the maximal strength and elongation of the film of example 20 is much higher. The tensile strength at 100 and 200 MPa is much more than that of example 9 and comparable with that of example 8. Regarding to example 8 there is a further advantage that no butanone oxime is released.

Table 6: mechanical properties of the films of a polyether polyurethane cured with adipic di-hydrazide regarding to the films of example 8 and of example 9.

Film of example	Mechanical properties (MPa) <sup>a)</sup>					
	M-100	M-200	M-300	M400	UTS	Elongation
8	2.6	3.8	-	-	4.7	260
9	0.6	1.2	-	-	1.3	220
20	2.8	4.4	5.8	7.7	7.8	405

notes to table 6:

a) MPa is megapascal ( $10^6 \text{ Nm}^{-2}$ ). The mechanical properties and the elongation are measured with films which were stretched at a thickness of 200  $\mu$ m on a MTS Synergie 200 apparatus. The values at M-100, M-200, M-300 and M400 give tensile strengths of the films while stretching them for respectively 100, 200, 300 and 400 %. The UTS



is the ultimate tensile strength just before the film breaks. The elongation is the maximal elongation before the film breaks.

5                   Example 21

Preparation of coatings on glass by curing a polyisocyanate and the adipic hydrazide dispersion of example 15A.

50 g of N,N',N''- tris(6-isocyanatohexyl)isocyanurate or of, N,N'-bis(6-isocyanato-hexyl-N-(6-isocyanato-hexylamido)urea was mixed with a stoichiometric amount of the adipic hydrazide dispersion of example 15A or of the carbodihydrazide dispersion of example 16. 200  $\mu$ m films were prepared on glass and heated for 6 min at 160°C. Hard coating surfaces were obtained with a good adhesion to the glass.

                  Example 22

Preparation of a film by curing a polyurethane prepolymer and a dispersion of a hydrogen reactive material of example 16.

50 g of the polyurethane prepolymer of example 2 was mixed with a stoichiometric amount of the dispersions of example 16 and the mixtures were applied onto release paper. The curing of the films was checked at 140 or 160°C after 3 min and after 12 min. When no film formation was observed the curing was checked at 220 and 250°C. The results are presented in tabel 7.

The results show that the dihydrazides, disemicarbazides and some diamine salts react with a isocyanate functional polyurethane prepolymer to form a film. These films are flexible. The table further shows that the reactivity of the used dihydrazides is comparable with that of the sulphonyldihydrazide used and both are more reactive than the semicarbazides used. The amine salts need a prolonged heating at higher temperatures before they react.

Table 7: Film formation by curing the polyurethane prepolymer of example 2 and a dihydrazide, disemicarbazide, and a diamine

Hydrogen reactive material	phase of the film <sup>a</sup> at a curing temperature and time of						
	140°C		160°C		220°C		250°C
	3 min	12 min	3 min	12 min	3 min	12 min	3 min
carbodihydrazide	r-i	r	r	r	--	--	--
oxalic dihydrazide	t	r	r	r	--	--	--
succinic dihydrazide	t	r	r	r	--	--	--
adipic dihydrazide	r	r	r	r	--	--	--
sebacic dihydrazide	r	r	r	r	--	--	--
dodecanoic dihydrazide	r	r	r	r	--	--	--
isophthaltic dihydrazide	r	r	r	r	--	--	--
4,4'-methylenebis- (cyclohexylisemicarbazide)	w	w	w	t	r	--	--
hexamethylene disemicarbazide	w	w	t	r	r	--	--
tolyldisemicarbazide	w	w	w	t	r	--	--
3-semicarbazidomethyl-3,5,5- trimethylcyclohexylsemi- carbazide 4,4'-oxybis- (benzenesulphonylhdydrazide)	w	w	w	r-i	r	--	--
guanidinehydrochloride	r	r	r	r	--	--	--
lysine	w	w	w	w	w	r	r-i
	w	w	w	w	t	r	r-i

5

## Notes to Table 7

a) w : the mixture is still wet; no reaction is observed

t : the mixture is tacky; a partial reaction is effected

10

r-i : film formation is effected, but the film is not strong, which means that the reaction is incomplete

r : complete film formation is effected

15

## Example 23

Preparation of a film by curing a polyepoxide and a adipic dihydrazide or a carbodihydrazide dispersion

50 g (138.7 mmole) of Tetrad-X, which is a polyepoxide material obtainable from Mitsubishi, was mixed with a stoichiometric amount of the adipic hydrazide dispersion of example 15 A or the carbodihydrazide of example 16. The products were applied onto release paper and heated at 140 and at 160°C. The mixtures were cured after 6 min at 160°C or after 3 min at 180°C. Brittle films were obtained.

25

## Example 24

Preparation of a film by curing a poly ketone functional compound and a adipic dihydrazide dispersion or a carbodihydrazide dispersion.

5           The products of example 5, 6 and 7 and a mixture 20 % of example 7 + 80 % of example 5 were mixed with a stoichiometric amount of the adipic dihydrazide dispersion of example 15 A or with the carbodihydrazide dispersion of example 16. The products were applied onto release paper.  
10 The films were cured at 160°C during 3 min. The film formation was complete. The films of the cured product of examples 5 and 6 were very soft, sticky and flexible. The film of the cured mixture was flexible and the film of the cured product of example 7 was very hard.

15

## Example 25

Preparation of a film by curing a polyanhydride functional compound and a adipic dihydrazide dispersion.

20 gr of the styrene/anhydride copolymers, known as SMA  
20 1000, SMA-2000 and SMA 3000 obtainable from Elf Atochem were mixed with 8 g of 1-methoxy-propanol at 80°C until the mixtures were dissolved. The solutions were cooled down and mixed with a stoichiometric amount of the adipic dihydrazide dispersion of example 15 A or with the carbodihydrazide dispersion of example 16 and applied onto glass  
25 or onto release paper. The mixtures were cured at 160°C for 6 min onto glass or for 4 min onto release paper. The coatings obtained were extremely hard and brittle.

30

## Example 26

Preparation of a coated textile to be used as synthetic leather.

A coated textile was prepared by direct coating comprising:

- 35 - Preparation of an adhesion coat onto textile: 150 µm of a mixture of 100 g RU-4049, 0.7 g of RM-4456, 5.0 g of XR-5580 and 5 g water (products obtainable from

- Stahl Holland) was applied onto textile by knife over roll and the coated textile was dried for 3 min at 80°C.
- Preparation of a coat from a solvent free material onto the thus obtained coated textile: 400  $\mu$  of a mixture of 100 g of the product of Example 1 and 21 g of the adipic hydrazide dispersion of example 15 A was applied onto the coated textile. The coating was cured in an oven at 160° for 3 min.
  - The coating was embossed at 190°C.

10

#### Example 27

Preparation of a double sided coated textile which may be used as synthetic leather.

- A double sided coated textile was prepared by direct coating by repeating the procedure of example 26 onto the other side of the textile.

#### Example 28

- Preparation of a coated textile to be used as synthetic leather by transfer coating.

A coated textile was prepared by transfer coating comprising:

- Preparation of a topcoat onto release paper: 150  $\mu$ m of a 1:1 mixture of RU-3952 and RU3953 (both are aqueous polyurethane dispersions obtainable from Stahl Holland) containing 10 % of PP-3215 (a black pigment obtainable from Stahl Holland) was applied onto release paper by knife over roll and the coated paper was dried at 80°C for 3 min.
- Preparation of an intermediate coat from a solvent free material onto the coated release paper: 400  $\mu$ m of a mixture of 100 g of the product of Example 1 and 21 g of the adipic hydrazide dispersion of example 15 A was applied onto the topcoat. The coating on the paper was cured in an oven at 160° for 3 min.
- Preparation of an adhesive coat onto the obtained intermediate coat: 150  $\mu$ m of SU-6241 (which is a solvent based polyurethane obtainable from Stahl Holland) contain-

ning 5 % of XR-8041 (which is a crosslinker obtainable from Stahl Holland) was applied onto the intermediate coat.

- A piece of textile was laminated into the adhesive and the thus obtained material was dried at 120°C for 2 min.
- The release paper was removed from the thus coated textile.

#### Example 29

Preparation of a coated materials by transfer coating.

The procedure of example 28 was repeated with the exception that the textile was replaced by leather, non-woven or a coagulated polyurethane substrate.

#### Example 30

Preparation of a coated polyvinylchloride to be used as synthetic leather by transfer coating.

- Preparation of a skincoat onto release paper: 150 µm of EX-51-550 (a solvent based polyurethane dispersions obtainable from Stahl Holland) was applied onto release paper by knife over roll and the coated paper was dried at 80°C for 3 min.
- Preparation of a coat from a high solids material onto the coated release paper: 400 µm of a mixture of 100 g of the product of Example 2 and 17 g of the adipic hydrazide dispersion of example 15 A was applied onto the topcoat. The coating on the paper was cured in an oven at 160° for 3 min
- Preparation of a compact polyvinylchloride substrate onto the high solids coat: 400 µm of a polyvinylchloride paste was applied onto the high-solids coat.
- a piece of textile was laminated in the polyvinyl chloride paste and the polyvinyl chloride was cured by 2 min at 160°C followed by 1 min at 220°C.
- the release paper was removed from the thus coated polyvinylchloride on textile.

## Example 31

Preparation of a moulded material by inmould coating.

A mixture of 100 g of example 2, 20 g of  
5 N,N',N''- tris(6-isocyanatohexyl)isocyanurate and 37 g of  
the adipic hydrazide dispersion of example 15 A was diluted with 50 g of butylacetate and heated to 50°C while  
mixing. The mixture was sprayed into a metallic matrix until a coating of about 400  $\mu\text{m}$  was obtained; the matrix was  
10 pretreated with a silicon and was heated at 180°C during  
the spray process. The matrix was cooled down and the  
moulded material was removed.

CLAIMS

1. The process for the preparation of a coating, adhesive, film or sheet **characterized**, in that a mixture of a polyisocyanate functional, a polyepoxide functional, a polyanhydride functional or a polyketone functional compound or polymer and a compound containing reactive hydrogen, in which the compound containing reactive hydrogen is dispersed in a material which is non-reactive towards the compound containing reactive hydrogen, which mixture is not or low reactive at ambient conditions and high reactive under selected conditions, is applied onto a substrate at ambient temperature, followed by reacting the above compounds at elevated temperatures.

2. The process according to claim 1, **characterized**, in that at ambient temperature said compound containing reactive hydrogen is a solid material, a powder, a granule, a flake or grind or a mixture thereof which is preferably ground.

3. The process according to claims 1 and 2, **characterized**, in that the actual size of the grind of said compound containing reactive hydrogen, is from 0.5 to 200  $\mu\text{m}$  and is preferably from 0.5 to 60  $\mu\text{m}$  and is more preferably from 0,5 to 15  $\mu\text{m}$ .

4. The process according to claims 1 to 3, **characterized**, in that said compound containing reactive hydrogen is a polyhydrazide, a polysemicarbazide, a polysulphonyl hydrazide, guanidine or a guanidine salt, a polyamine or blocked polyamine or is carbodihydrazide.

5. The process according to claim 4, **characterized**, in that said polyhydrazide is oxalic dihydrazide, malonic dihydrazide, succinic dihydrazide, adipic dihydrazide, sebacic dihydrazide, dodecanoic dihydrazide, isophthalic dihydrazide, piperazine N,N'-dihydrazide, m-benzene-dihydrazide, p-benzene-dihydrazide.

6. The process according to claims 4 or 5, characterized, in that the polyhydrazide is adipic dihydrazide or carbodihydrazide.

7. The process according to claim 4, characterized, in that said polysemicarbazide is ethane-disemicarbazide, butane-disemicarbazide, propane-disemicarbazide, hexane-disemicarbazide, para-benzene-disemicarbazide, toluene-2,4-disemicarbazide, toluene-2,4-disemicarbazide, bis (4-semicarbazido-phenyl)ether, bis (4,4'-hydrazido)-3,3'-dimethoxy biphenyl, di-N,N'-methylamino urea, 4,4'-methylene-bis(cyclohexene semicarbazide), 3-semicarbazido-methyl-3,5,5-trimethylcyclohexyl-semicarbazide or mixtures thereof.

8. The process according to claim 4, characterized, in that said polysulphonyl hydrazide is p,p'-oxybis benzene sulphonyl hydrazide; bis(methylhydrazido)sulphate, bis (methylhydrazidosulphonyl)piperazine, bis p-(hydrazidosulphonylamino)benzene.

9. The process according to claim 4, characterized, in that the guanidine salt is guanidine hydrochloride, guanidine acetate, guanidine carbonate, guanidine nitrate.

10. The process according to claim 4, characterized, in that the polyamine or polyamine salt is piperazine, piperazine diacetate, piperazine dihydrochloride, lysine, lysine hydrate, diaminoisophorone diacetate, diaminoisophorone dihydrochloride.

11. The process according to claim 1, characterized, in that the material of claim 1 which is non-reactive towards said compound containing reactive hydrogen, is a polyether, a polyester, a polycarbonate, a polyacrylate, a polyvinylalkylether, a polyurethane, optionally substituted by substituents which are non reactive towards the material containing reactive hydrogen, and non- or low reactive towards the isocyanate functional material or is a plasticizer of the group of phthalic alkylesters, adipic alkyl esters, sebacic alkyl esters, dodecanoic alkyl esters, polyesters, phosphate esters, fatty esters, straight



and modified natural or mineral oils, sulphonated oils, ethoxylated oils, epoxidised oils, fatty acids, sulphon amides, fat liquors, lecithine or a mixture thereof, optionally mixed with water.

5           12. The process according to claims 1-11, **characterized**, in that the said mixture of the polyisocyanate functional, the polyepoxy functional, or the polyketone functional compound or polymer and the compound containing reactive hydrogen, is solvent free.

10           13. The process according to claims 1-12, **characterized**, in that said polyisocyanate functional compound or polymer and said compound containing reactive hydrogen are mixed together in a stoichiometric ratio of 0.5 to 1.5, and preferably in a ratio of 0.9 to 1.1, applied onto  
15 a substrate and the so obtained covered or impregnated substrate is heated to a temperature of 50 to 300 °C for 1 to 20 min and preferably to a temperature of 80 to 200 °C for 1 to 10 min.

          14. The process according to claims 1-12, **characterized**, in that said polyisocyanate functional compound  
20 or polymer and said compound containing reactive hydrogen are mixed together in a equivalent ratio of 0.5 to 1.5, and preferably in a ratio of 0.9 to 1.1, and applied onto a substrate whereafter the covered or impregnated substrate  
25 is immersed into water of 20 to 100 °C for 1 to 10 min.

          15. Coatings, coated substrates, adhesives, films, sheets, impregnated substrates, synthetic leathers, inmould coatings, coated leathers, coated polyvinylchlorides, coated non-wovens, coated coagulated polyurethane  
30 substrates, breathable coated substrates, **characterised**, in that they are obtained by applying the process of any of the preceeding claims 1-14.

          16. A coating mixture comprising a mixture of a polyisocyanate functional compound, a polyepoxide functional  
35 nal compound, a polyanhydride functional compound or a polyketone functional compound, and a compound containing reactive hydrogen which is not or low reactive at ambient temperature and highly reactive under selected conditions,

which coating mixture is applied in the process of claim 1 to 15.

17. A coating mixture according to claims 1-16, characterized, in that the mixture of the polyisocyanate functional compound, the polyepoxide functional compound, the polyanhydride functional compound or the polyketone functional compound or polymers thereof and the compound containing reactive hydrogen is stable at ambient temperature for at least one day.

18. A coating mixture according to claims 16 or 17, characterized, in that the mixture of the polyepoxide functional compound, the polyanhydride functional compound or the polyketone functional compound or polymers thereof and the compound containing reactive hydrogen is stable at ambient temperature as a one pot system.

19. A coating mixture according to claims 16-18, characterized, in that the compound containing reactive hydrogen is present as grind which is dispersed in a material which is non-reactive towards the material containing reactive hydrogen.

20. A coating mixture according to claims 16-18, characterized, in that at ambient temperature the compound containing reactive hydrogen is a solid, which is a powder, a granule, a flake or a grind or a mixture thereof, which is preferably ground.

21. A coating mixture according to claims 16-18, characterized, in that the particle size of the ground or of the dispersion of the compound containing reactive hydrogen is from 0,5 to 200  $\mu\text{m}$ , preferably from 0.5 to 60  $\mu\text{m}$  and most preferably from 0.5 to 15  $\mu\text{m}$ .

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
5 April 2001 (05.04.2001)

PCT

(10) International Publication Number  
**WO 01/23451 A3**

- (51) International Patent Classification<sup>7</sup>: C08G 18/08. (74) Agent: KUPECZ, Arpad; Octrooibureau Los en Stijter B.V., Weteringschans 96, NL-1017 XS Amsterdam (NL).  
18/10, C09J 175/02
- (21) International Application Number: PCT/NL(X)/00699 (81) Designated States (*national*): AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
- (22) International Filing Date:  
29 September 2000 (29.09.2000)
- (25) Filing Language: English
- (26) Publication Language: English (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).
- (30) Priority Data:  
1013179 30 September 1999 (30.09.1999) NL
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- Published:  
— with international search report
- (72) Inventors; and (88) Date of publication of the international search report:  
25 October 2001
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- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

(54) Title: PROCESS FOR THE PREPARATION OF A COATING, A COATED SUBSTRATE, AN ADHESIVE, A FILM OR SHEET, FOR THE THUS OBTAINED PRODUCTS AND THE COATING MIXTURE TO BE USED IN THE PROCESS

(57) Abstract: The invention comprises a process for the preparation of a coating, adhesive, film or sheet. In this process a mixture of a polyisocyanate functional, a polyepoxide functional, a polyanhydride functional or a polyketone functional compound or polymer and a compound containing reactive hydrogen, in which the compound containing reactive hydrogen is dispersed in a material which is non-reactive towards the compound containing reactive hydrogen, which mixture is not or low reactive at ambient conditions and high reactive under selected conditions, is applied onto a substrate at ambient temperature, followed by reacting the above compounds at elevated temperatures. At ambient temperature said compound containing reactive hydrogen is a solid material, a powder, a granule, a flake or grind or a mixture thereof which is preferably ground. The invention comprises further the coating mixtures to be used in the process and the coatings, coated substrates, adhesives, films, sheets, impregnated substrates, synthetic leathers, inmould coatings, coated leathers, coated polyvinylchlorides, coated non-wovens, coated coagulated polyurethane substrates, breathable coated substrates, obtained by applying the process.

WO 01/23451 A3

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/NL 00/00699

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C08G18/08 C08G18/10 C09J175/02

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C08G C09J

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

WPI Data, EPO-Internal, PAJ

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No
X	US 4 912 152 A (NEJIGAKI ET AL) 27 March 1990 (1990-03-27) column 1, line 43 -column 7, line 22; claims	1-7, 11, 16, 18, 19
X	EP 0 171 015 A (BAYER) 27 November 1985 (1985-11-27) page 1, line 1 -page 3, line 2 page 7, line 22 -page 21, line 16 page 47, line 24 -page 53, line 20	1, 2
X	US 4 552 913 A (WOLFE ET AL) 12 November 1985 (1985-11-12) column 1, line 59 -column 2, line 65; claims 1, 2	1

☒ Further documents are listed in the continuation of box C

☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

24 January 2001

Date of mailing of the international search report

06/02/2001

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International Application No  
PCT/NL 00/00699

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